

Work Order ID 67427

Monday, March 21, 2011 7:25:28 AM



Page 1

Item ID: D3838-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 3/21/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: MDate: 11-03-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3838

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3838-1 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

SAD

11-04-21

4- weld D3838-1 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838

A/R ER316 S.S. Rod Batch: 115928

5- c'sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: 115928

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

②

PC 11.05.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67427

Page 2

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Item ID: D3838-041

Accept



Setup Start



Revision ID:

Stop



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Start Date: 3/21/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

BE
*PL 11.05.05**2**Ø*

QC

Memo

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

*B/E**PL 11.05.05**(x2)*
W/

W/O:		WORK ORDER CHANGES					
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Work Order ID 67427


Monday, March 21, 2011 7:25:28 AM



Page 3

Item ID: D3838-041 Accept  Setup Start 
Revision ID:
Item Name: Rib Assembly (Basket Lid, LH) Stop 
Start Date: 3/21/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 3/31/2011 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

MF
11-05-05

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, March 21, 2011 7:25:34 AM

Page 1

Work Order ID: 67427

Parent Item: D3838-041

Parent Item Name: Rib Assembly (Basket Lid, LH)



Start Date: 3/21/2011

Required Date: 3/31/2011

Start Qty: 2.00

Required Qty: 2.00


Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1		Manufactured	No				Each	384.0000		2			
													
Bushing													

Location Loc Qty Loc Code

WA	200	
66870	200	
WA005	184	
54072	9	
66107	42	
66489	133	

M304TS0.750W.065		Purchased	No			100	f	1,200.429	1.0317	2.172			
													
304 SQ Tube .75x.75x.065W													

Location Loc Qty Loc Code

WA007	1200.4298	
116267	200.4298	
116763	1000	

CP 11.05.04

SM 11-04-22

2.172

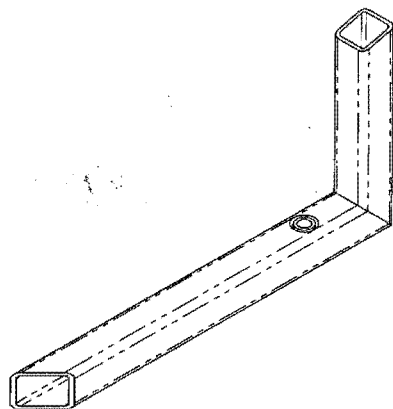
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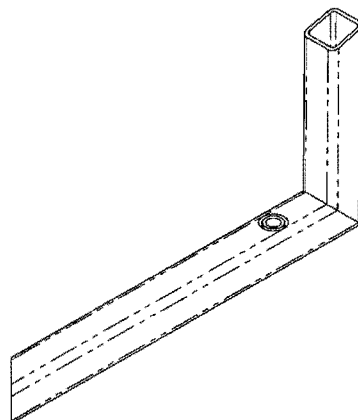
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NOTE: Date & initial all entries



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67427

PI 11-03-21

RELEASED
08/11/08

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.54 lbs

A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3838** REV. A
SHEET 1 OF 3

TITLE **RIB ASSY (BASKET LID)** SCALE NTS

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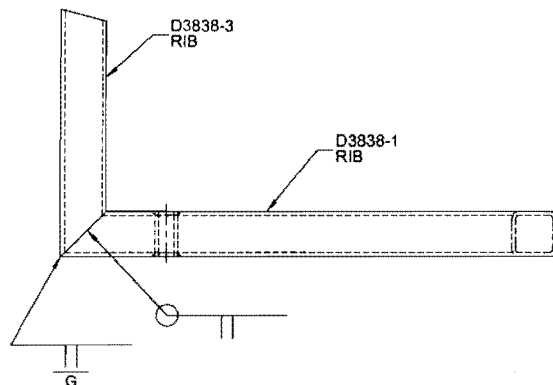
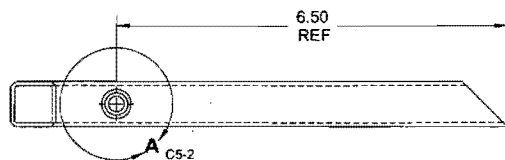
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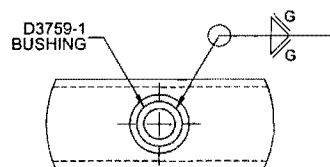
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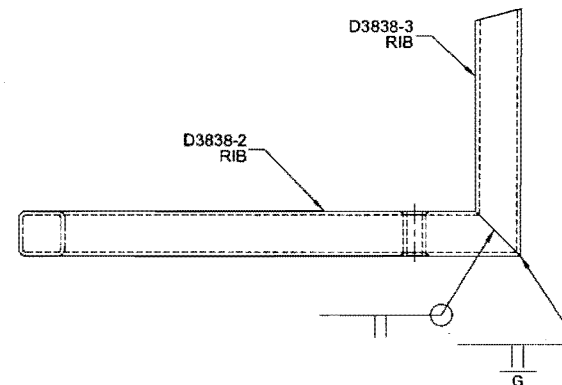
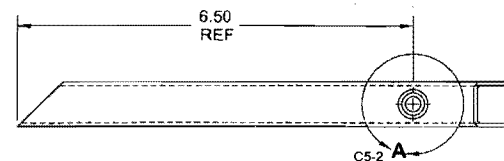
NOTE: Date & initial all entries



D3838-041 RIB ASSY (BASKET LID, LH)



DETAIL A
D2-2
D7-2 SCALE 2X



D3838-042 RIB ASSY (BASKET LID, LH)

RELEASED
08/11/81

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3838	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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W067427

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

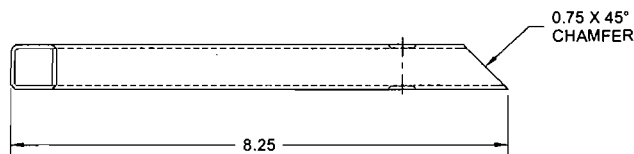
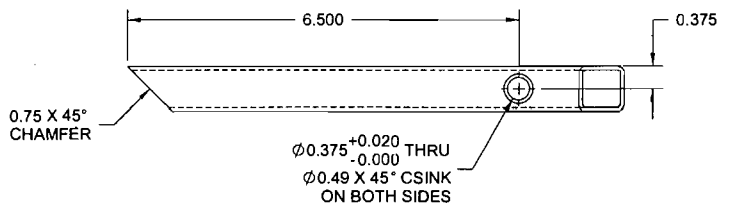
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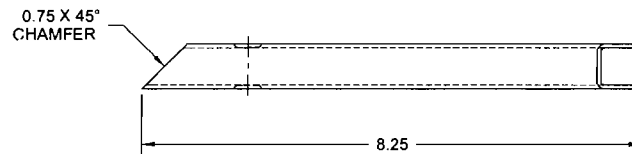
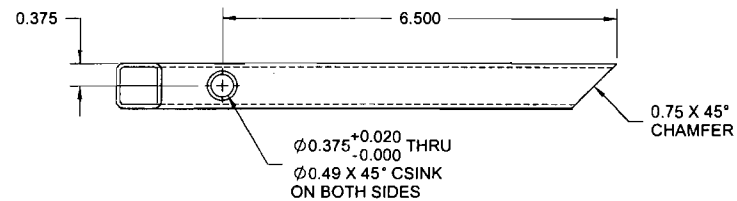
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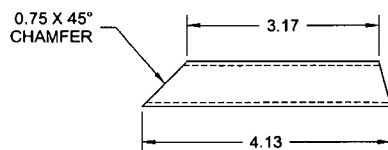
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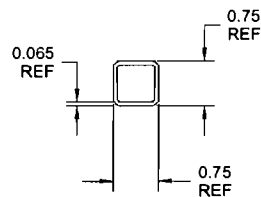
D3838-1 RIB



D3838-2 RIB



D3838-3 RIB



TYPICAL SECTION VIEW

W667427

RELEASED

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3838	REV. A
MFG. APPR.		TITLE RIB ASSY (BASKET LID)	SHEET 3 OF 3
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8 7 6 5 4 3 2 1

A

A

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